

## Claims

1. A knitted fabric joining method wherein at least two tubular knitted fabrics, each comprising a front knitted fabric part and a back knitted fabric part, are knitted in succession in a direction of course and overlapped with each other at their joining region at which gores of different in size between the front knitted fabric part and the back knitted fabric part are formed, thereby being joined together, using a flat knitting machine comprising at least a pair of front and back needle beds, which extend in a longitudinal direction and are located in opposed positions in a cross direction and at least either of which is capable of being racked in the longitudinal direction, the method comprising:

the step that in a knitted fabric joining step, in a joining region of the front knitted fabric part and a joining region of the back knitted fabric part which are arranged on the opposed needle beds, loops in the joining region of a small gore and loops in the joining region of a large gore are situated in the joining regions containing needles in equal number, respectively, and the loops in the joining region of the one gore are held on an every two or three needle basis and the loops in the joining region of the other gore are held on an every needle basis so that both ends of the one joining region and both ends of the other joining region can substantially correspond in position to each other and, then, loops of the one tubular knitted fabric which are situated in the joining region and located at a lateral end thereof and loops of the other tubular knitted fabric which are situated in the joining region and located at a lateral end thereof, the loops of the tubular knitted fabrics

being to be joined to each other, are overlapped with each other in such a manner that the loops located adjacent to each other with respect to a boundary between the front knitted fabric part and the back knitted fabric part are overlapped with each other and the loops located far away from each other with respect to the boundary are overlapped with each other and then are subjected to the bind-off process, thereby forming a gore at a joining portion of the tubular knitted fabric and, subsequent to the joining of the tubular knitted fabrics, knitting a single tubular knitted fabric.

2. The knitted fabric joining method according to Claim 1, which is for joining the first knitted fabric and the second knitted fabric, and which comprises the following steps to be taken before the start of the joining of the first and second knitted fabrics:

(1) the first step that the loops in the joining region of one of the front knitted fabric part and the back knitted fabric part of the first knitted fabric are transferred to the opposed needle bed,

(2) the second step that the second knitted fabric is subjected to rotation of the knitting while either the front needle bed or the back needle bed being racked in either rightward or leftward, and the loops in the joining region as transferred in the first step are sequentially transferred back to the opposed needle bed starting from the loop located at the end far from the second knitted fabric while the first knitted fabric being subjected to the rotation of the knitting for the loops of the first knitted fabric located at end portions thereof far from the second knitted fabric to be transferred to the opposed needle bed, those operations being repeated so that the loops can be arranged on an every two or three needle or an every needle basis in

the joining region of the first knitted fabric,

(3) the third step that the loops in the joining region of the other knitted fabric part, which corresponds in size to the joining rejoin of one of the front knitted fabric part or the back knitted fabric part of the second  
5 knitted fabric from which the loops were transferred in the first step, are transferred to the opposed needle bed, and

(4) the fourth step that the first knitted fabric is subjected to rotation of the knitting while either the front needle bed or the back needle bed being racked in a direction opposite to the direction of the needle bed being racked  
10 in the second step, and the loops in the joining region as transferred in the third step are sequentially transferred back to the opposed needle bed starting from the loop located at the end far from the first knitted fabric while the second knitted fabric being subjected to the rotation of the knitting for the loops of the second knitted fabric located at end portions  
15 thereof far from the first knitted fabric to be transferred to the opposed needle bed, those operations being repeated so that the loops can be arranged on an every two or three needle or an every needle basis in the joining region of the second knitted fabric.

3. The knitted fabric joining method according to Claim 1, which is for  
20 knitting the second knitted fabric, the third knitted fabric and the first knitted fabric sandwiched between the second and third knitted fabrics, followed by joining of the second and third knitted fabrics to the first knitted fabric, and which comprises the following steps to be taken before the start of joining of the first, second, and third knitted fabrics:

25 (1) the first step that the loops in the joining region of one of the front

knitted fabric part and the back knitted fabric part of the first knitted fabric to be joined to the second knitted fabric are transferred to the opposed needle bed, while also the loops in the joining region of the third knitted fabric having the gore, which corresponds in size to the joining rejoin of the first knitted fabric from which the loops were transferred, are transferred to the opposed needle bed,

(2) the second step that the second knitted fabric is subjected to rotation of the knitting while either the front needle bed or the back needle bed being racked in either rightward or leftward, and the loops in the joining region as transferred in the first step are sequentially transferred back to the opposed needle bed starting from the loop located at the end far from the second knitted fabric while the first and third knitted fabrics being subjected to the rotation of the knitting for the loops of the first and third knitted fabrics located at end portions thereof far from the second knitted fabric to be transferred to the opposed needle bed, those operations being repeated so that the loops can be arranged on an every two or three needle or an every needle basis in the joining regions of the first knitted fabric and the third knitted fabric,

(3) the third step that the loops in the joining region of the first knitted fabric to be joined to the third knitted fabric, which corresponds in size to the joining rejoin from which the loops were transferred in the first step, are transferred to the opposed needle bed, while also the loops in the joining region of the second knitted fabric, which corresponds in size to the joining rejoin of the first knitted fabric from which the loops were transferred, are transferred to the opposed needle bed, and

(4) the fourth step that the third knitted fabric is subjected to rotation of the knitting while either the front needle bed or the back needle bed being racked in a direction opposite to the direction of the needle bed being racked in the second step, and the loops in the joining region as transferred in the  
5 third step are sequentially transferred back to the opposed needle bed starting from the loop located at the end far from the third knitted fabric while the first and second knitted fabrics being subjected to the rotation of the knitting for the loops of the first and second knitted fabrics located at end portions thereof far from the third knitted fabric to be transferred to the  
10 opposed needle bed, those operations being repeated so that the loops can be arranged on an every two or three needle or an every needle basis in the joining region of the first and second knitted fabrics.